

Work Order ID 110582

Thursday, January 02, 2014 10:14:54 AM

110582

Page 1

Item ID: D4882-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Leg Assembly
 Start Date: 1/2/2014 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 1/31/2014 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: ME Date: 14-01-02 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4882	A								

110 0.00
110
 Small Fab Memo 0.00 2 FF
 Small Fab ALIGN PILOT HOLES IN D4882-1 WITH PILOT HOLES IN D4883-3 AND 14-04-17
 D4884-1. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER
 DWG.
 REAM EACH HOLES USING REAMER, USING DART TOOL SETUP
 DT9975 AS PER DWG. DAS
 27
 9-83
 120 QC5- Inspect part completeness to step on W/O. 0.00 2
120
 QC Memo 0.00
 Quality Control

Thursday, January 02, 2014 10:14:54 AM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

?

Cust Item ID:

Start Date: 1/2/2014 **Start Qty:** 2.00

Required Date: 1/31/2014 **Req'd Qty:** 2.00

~

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

Work Order ID 110582

Thursday, January 02, 2014 10:14:54 AM

110582

Page 3

Item ID: D4882-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Leg Assembly
Start Date: 1/2/2014 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 1/31/2014 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 14-04-21

14-4-21

Picklist Print

Thursday, January 02, 2014 10:14:53 AM

Page 1

Work Order ID: 110582

Parent Item: D4882-041

Parent Item Name: Leg Assembly

Start Date: 1/2/2014

Required Date: 1/31/2014

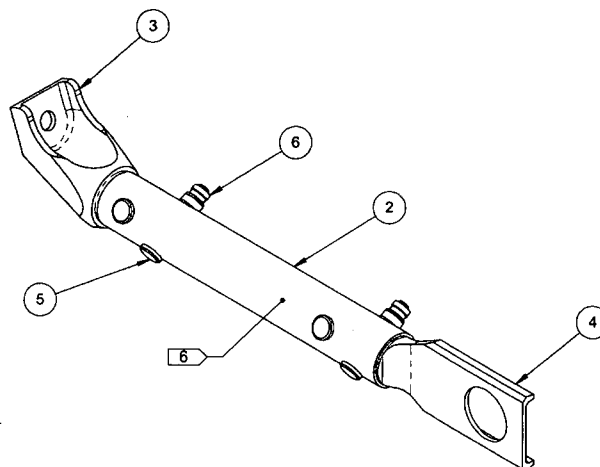
Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4882-1 Strut		Manufactured	No	111340 115543			Each	0.0000		2 1	FF	14-04-17	
D4883-3 End Fitting		Manufactured	No	113534			Each	0.0000		2 2	FF	14-04-17	
D4884-1 End Fitting, Eye		Manufactured	No	112029			Each	0.0000		2 2	FF	14-04-17	
HL20PB5-12 Rivet		Purchased	No	128110			Each	0.0000		8 8	FF	14-04-17	
HL86-5 Collar		Purchased	No				Each	21.0000		8 8	FF	14-04-17	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST283	128110	21				8			
				121866		21							

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4882-041	LEG ASSEMBLY
2	1	D4882-1	STRUT
3	1	D4883-3	END FITTING
4	1	D4884-1	END FITTING, EYE
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4882-041 LEG ASSEMBLY

NOTES:

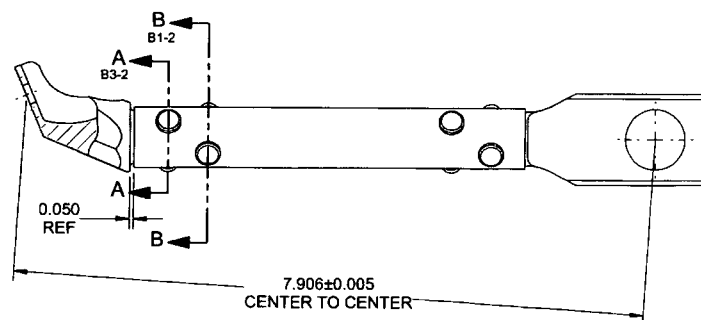
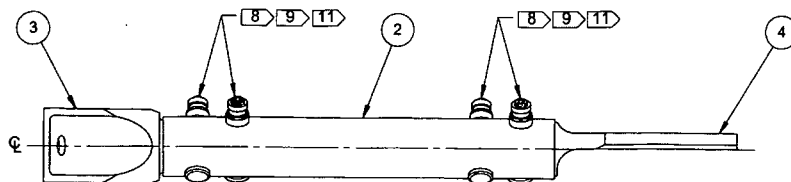
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.50 lbs
- 8) ALIGN PILOT HOLES IN D4882-1 WITH PILOT HOLES IN D4883-3 & D4884-1.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9975
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9975
- 11) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

MF
14-1-2
#110582

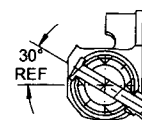
RELEASED
2013-12-12

APPROVED

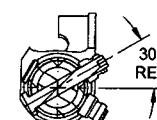
A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4882	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
DATE	13.12.09	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4882-041 LEG ASSEMBLY
AUXILIARY VIEW



SECTION A-A C7-2
2 PL



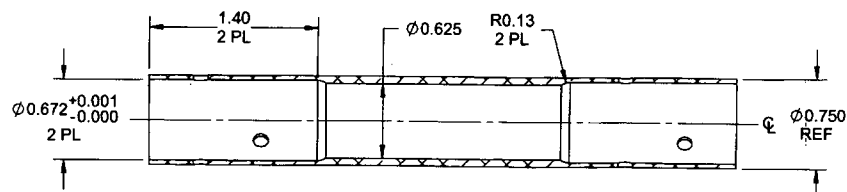
SECTION B-B C7-2

#110582

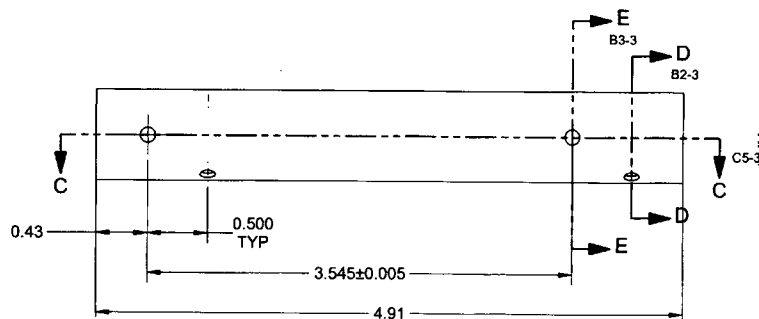
2013-12-12

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. D4882	REV. A
MFG. APPR.	JLM	TITLE LEG ASSEMBLY	SHEET 2 OF 3
APPROVED	HS		SCALE
DE APPR.	DS		NTS
DATE	13.12.09	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



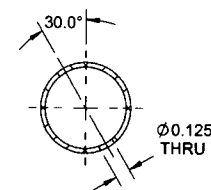
SECTION C-C B4-3



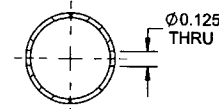
D4882-1 STRUT

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.15 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)



SECTION D-D C4-3
2 PL



SECTION E-E C4-3
2 PL

RELEASED
2013-12-12
MP

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4882	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
DATE	13.12.09	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	